

Work Order ID 75574

October-25-11 3:07:53 PM

\*75574\*

Nov 8/11

Item ID: D3324-041 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Basket Base Assembly  
Start Date: 25/10/2011 Start Qty: 1.00 \*1\* Cust Item ID:  
Required Date: 08/11/2011 Req'd Qty: 1.00 \*1\* Customer:  
Reference:

Approvals: Process Plan: M.L.J Date: 11/10/25 Tooling: Date: Run Start \*NR1\*  
QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3324	Rev B								

100

\*100\*

Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

1-Cut tubes as per Dwg D3324

Qty	Part Number	Description	Batch
3	D3324-1	Bottom Tube	M109127
4	D3324-3	Full Length Tube	M119491
2	D3324-5	Top End Tube	M109127
2	D3324-7	Bottom End Tube	M109127
10	D3324-9	Vertical Tube	M109127

2- Weld as per dwg

A/R 4130 rod batch: 118875

11/11/03

PC 11.11.03

110

\*110\*

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

1 0 2E 11/11/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*75574\***

Page 2

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 25/10/2011      **Start Qty:** 1.00

**\* 1 \***

**Cust Item ID:**

**Required Date: 08/11/2011      Req'd Qty: 1.00**

**\* 1 \***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**

### Process Plan:

Date:

**Tooling:**

Date:

Stop \*NR2\*

**QC:**

Date:

**SPC (Y/N):**

Date:

**Insp.  
Stamp**

QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

## Memo

0.00

## Quality Control

121

Pressure Wash per QSI005 4.3

0.00

**\*121\***

HandFinish

## Memo

0.00

## Hand Finishing

11-11-03 (r)

IXØ m-11/11/03

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Powdercoat Powder Coating  WV 8439	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo 1ST COAT: 2-10 START TIME: 400 0 F OVEN TEMPERATURE: 400 FINISH TIME: 2-40 ***** 2nd coat if necessary ***** 2ND COAT: START TIME: OVEN TEMPERATURE:	0.00							1 X M-L 11/11/03
140 <b>*140*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00							1 BR 11-11-03

W/O:		WORK ORDER CHANGES					
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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 <b>*150*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>G.A</u>  Memo <u>w/o</u> <u>75569</u>	0.00  0.00							<u>EP 11/11/07</u> <u>0</u>
160 <b>*160*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							<u>W 11/17</u> <u>0</u>

11-11-07 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

October-25-11 3:07:57 PM

Page 1

Work Order ID: 75574

**\*75574\***

Parent Item: D3324-041

**\*D3324-041\***

Parent Item Name: Basket Base Assembly

Start Date: 25/10/2011

Required Date: 08/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A05.02.09New issueKJ/JLM  
IPP Rev:B 08-12-16 attach DEO DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3328-3 <b>*D3328-3*</b> Basket Hinge		Manufactured	No			100	Each	24.0000	2	2	**	11/10/26	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				24					
				33872				24					
D3348-1 <b>*D3348-1*</b> Clevis		Manufactured	No			100	Each	5.0000	5	5	**	11/11/03	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				5					
				44246				5					
D3349-3 <b>*D3349-3*</b> Spacer Bushing		Manufactured	No			100	Each	10.0000	2	2	**	11/10/26	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				10					
				72930				10					
D3367-1 <b>*D3367-1*</b> Mounting Bracket		Manufactured	No			100	Each	20.0000	2	2	**	11/10/26	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				20					
				43228				20					

W/O:		WORK ORDER CHANGES					
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Parent Item: D3324-041

**\*D3324-041\***

Parent Item Name: Basket Base Assembly

Start Date: 25/10/2011

Required Date: 08/11/2011

Start Qty: 1.00

Required Qty: 1.00

M4130NTS0.500W.035

Purchased

No

100

f

270.9988

46.6

49.05263

**\*M4130NTS0 500W 035\***

4130 Square tube .500 x .500 x .035w

\*\*

B119441 43.25  
11/10/26  
5.8 + 2.9 END BAR  
SCRAP

Location

Loc Qty

Loc Code

MAT034

270.9988

109127

216

109385

15.75

112786

39.2488

M569EX0.50-18F

Purchased

No

100

sf

78.0000

28

28

**\*M569FX0 50-18F\***

569 Expanded Metal

\*\*

11/10/27

Location

Loc Qty

Loc Code

MAT018

78

112776

10

117806

4

119226

64

32

October-25-11 3:07:57 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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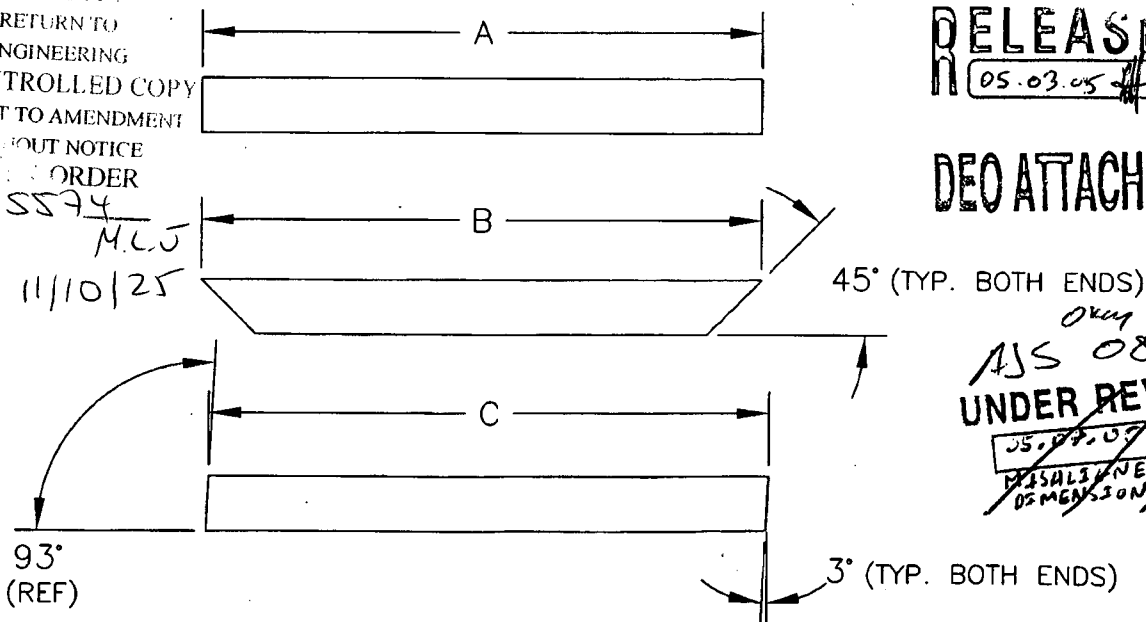
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CHECKED <b>PH</b>	APPROVED <b>PH</b>	DRAWING NO. D3324	REV. B SHEET 1 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE NTS
A	04.10.20	NEW ISSUE	
B	05.03.04	UPDATE MESH MATERIAL SPEC	

PARTS LIST FOR D3324-041 BASKET BASE ASSEMBLY

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3324-1	3	14.00	N/A	N/A	BOTTOM TUBE
D3324-3	4	N/A	86.50	N/A	FULL LENGTH TUBE
D3324-5	2	N/A	16.00	N/A	TOP END TUBE
D3324-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3324-9	10	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
NOT TO AMENDMENT  
WITHOUT NOTICE  
ORDER

75574  
M.L.J  
11/10/25



RELEASED  
05.03.05

DEO ATTACHED

OKAY  
JSS 08.12.15  
UNDER REVIEW  
05.03.05 PH  
REALIGNED  
DIMENSION P&A

D3324-1/-3/-5/-7/-9

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035 WALL (REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

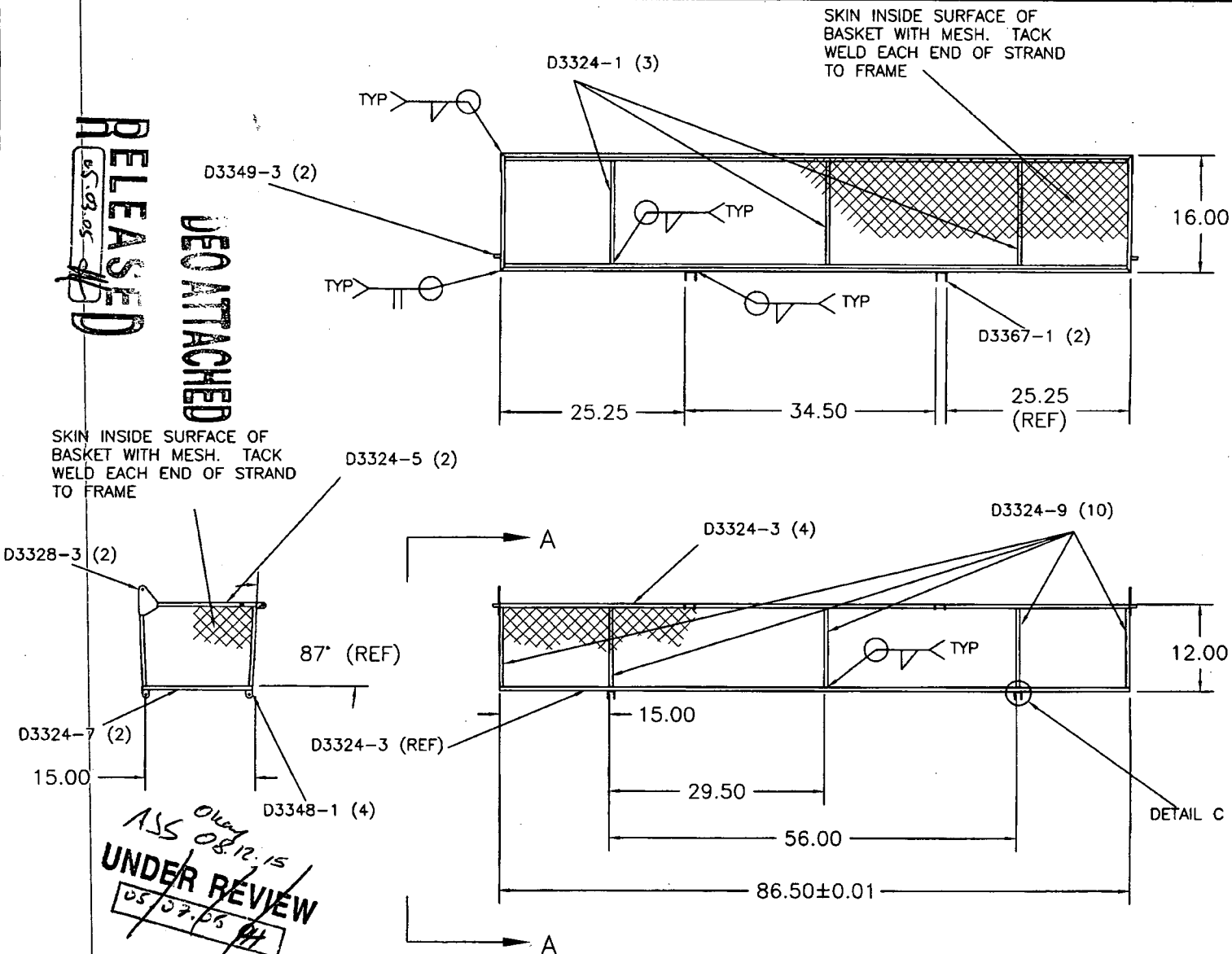
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**NOTE:** Date & initial all entries

75574



DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	05.03.04	TITLE	BASKET BASE ASSEMBLY	REV. B
		DRAWING NO.	D3324	SHEET 2 OF 3
		SCALE	1:20	



**D3324-041 BASKET BASE ASSEMBLY**

- 1) MESH MATERIAL: 1/2" - 18F GAUGE FLATTENED (0.040 THICK) EXPANDED CARBON STEEL (REF. DART SPEC. M569EX0.50-18F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 4.0 UNLESS OTHERWISE NOTED

**RELEASED**  
05.03.05  
**UNO ATTACHED**

ASS 08.12.15  
**UNDER REVIEW**  
05.07.05

W/O:		WORK ORDER CHANGES					
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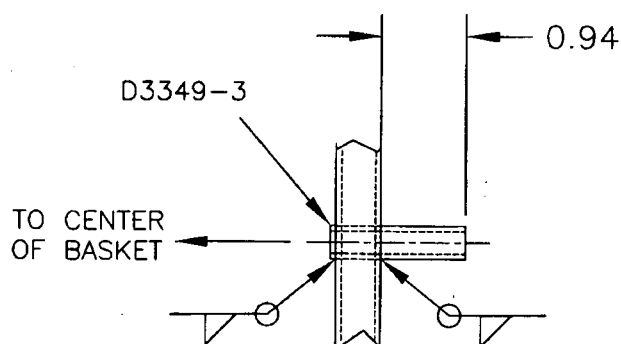
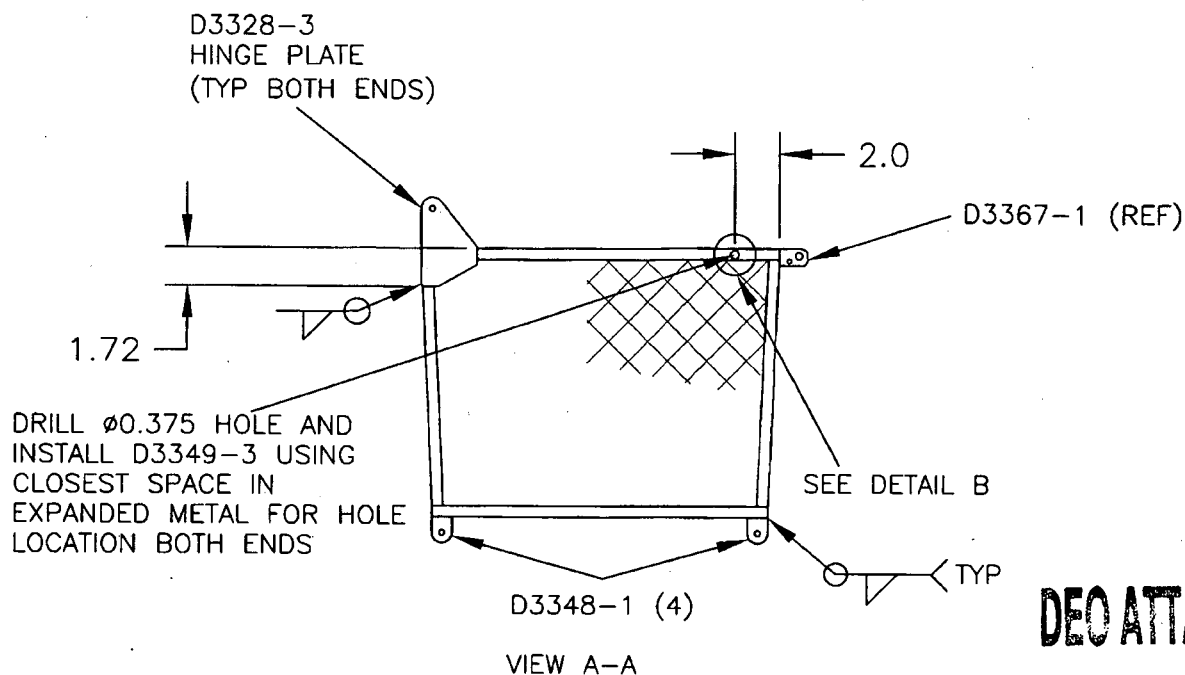
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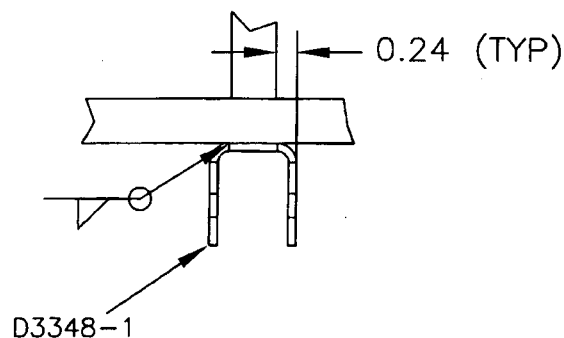




DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3324	REV. B SHEET 3 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE 1:8



DETAIL B  
(SCALE 1:2)



DETAIL C  
(SCALE 1:2)

*Okay*  
ASS 08.12.15  
**UNDER REVIEW**  
08.07.06

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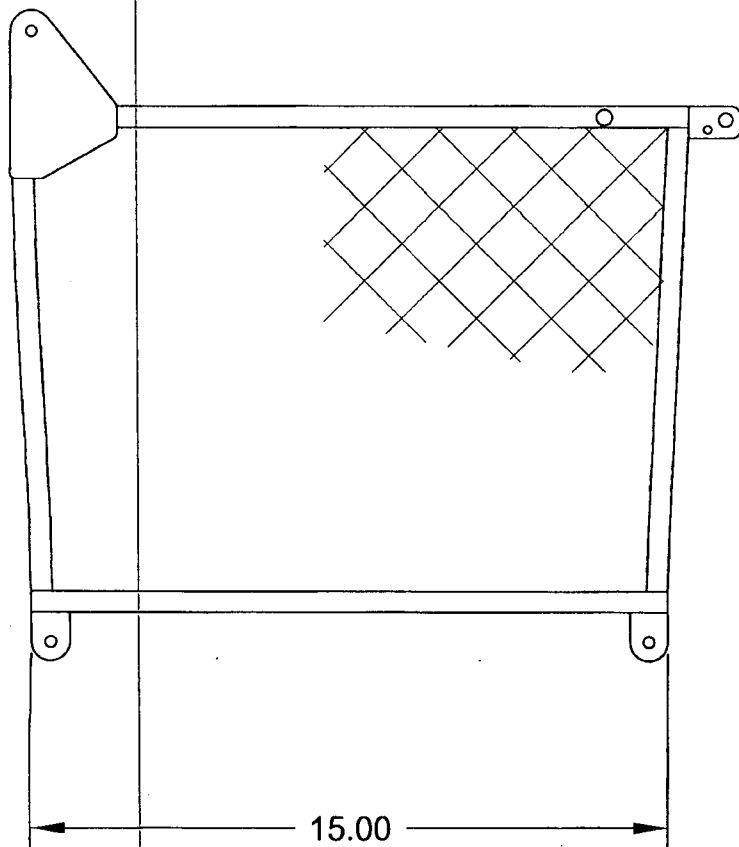
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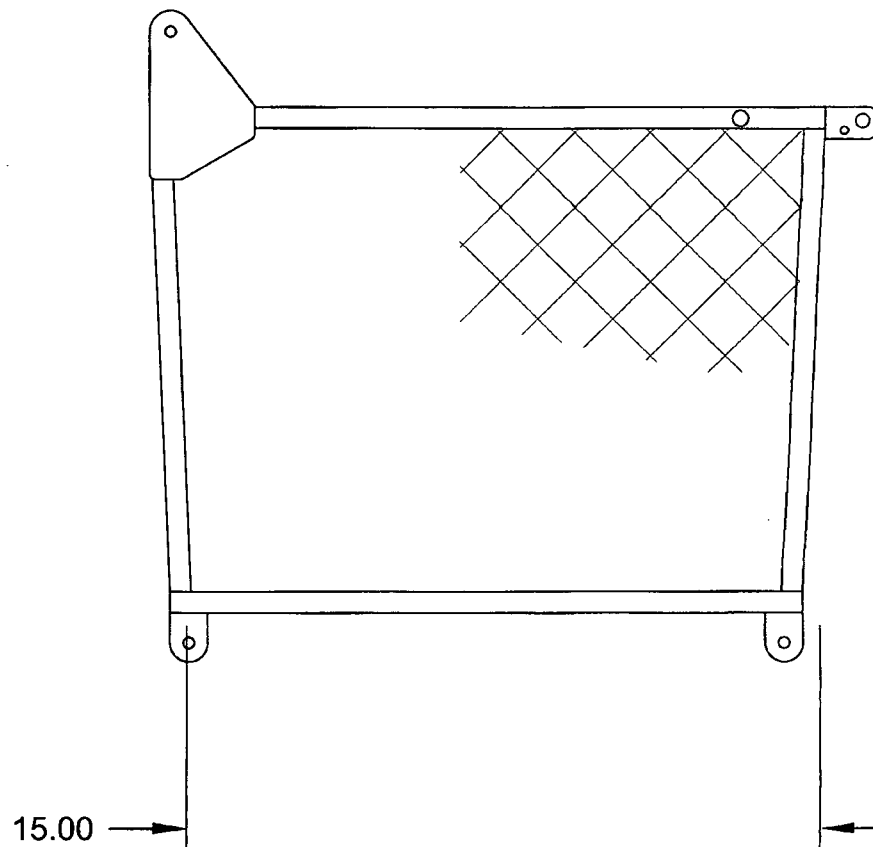
DRAWING NO. D3324		TITLE BASKET BASE ASSEMBLY		REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3324-B-1		SHEET NO. SHEET 1 OF 1		SCALE NTS
DRAWN AJS		CHECKED		MFG. APPR.		APPROVED		DE APPR.			
DATE 08.11.28		DATE 08.11.28		DATE 08/12/01		DATE 08/12/01		DATE 08.12.01			

SHEET 2 MODIFY SIDE VIEW OF D3324-041 AS SHOWN:

IS:



WAS:



W/O:		WORK ORDER CHANGES					
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